

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008732**Date Inspected:** 17-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Component: OBG & TOWER Components

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 2**Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB3098 – 001 – 018
2. FB3013 – 003 – 016
3. FB3046 – 001 – 014
4. FB3047 – 001 – 014
5. FB3062 – 001 – 020
6. FB3033 – 001 – 023
7. FB3008 – 001 – 002
8. FB3035 – 001 – 002
9. FB3036 – 001 – 002
10. FB3004 – 001 – 014

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

11. FB3034 – 001 – 014

BAY 3

Ultrasonic Testing

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. FB204 – 011 – 148
2. FB023 – 010 – 021; 125; 126; 127
3. FB023 – 001 – 125; 126; 127

BAY 5

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #001; 002 located on Bike Path BK001 – 026. Welder is identified as 204733. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

SMAW process welding of weld joint #064; 065 located on Bike Path BK001 – 032. Welder is identified as 203176. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY 6

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #020 located on WD1 – A305 – 77M – 3. Welder is identified as 066456. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #028 located on WD1 – A305 – 77M – 3. Welder is identified as 037780. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

SMAW process welding of weld joint #051 located on WD1 – A305 – 77M – 3. Welder is identified as 066456. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Side Plate SP3042 – 001. Welder is identified as 053609. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

FCAW process welding of weld joint #005 located on Edge Plate EP3006 – 001. Welder is identified as 062447. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #010 located on Side Plate SP3042 – 001. Welder is identified as 051246. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #012 located on Edge Plate EP3006 – 001. Welder is identified as 205774. ZPMC QC is identified as Zhou Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

BAY 8

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #034 located on Floor Beam FB205 – 038. Welder is identified as 066687. ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SAW process welding of weld joint #001 located on Cross Beam CB202C – 013. Welder is identified as 207463. ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

FCAW process welding of weld joint #006 located on Floor Beam FB205 – 040. Welder is identified as 066687. ZPMC QC is identified as Zhang Jing Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Prue,Erik	QA Reviewer
---------------------	-----------	-------------